



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

5053095

RBST1016-5
Job Sheet 170733



Part No: RBST1016-5

Job Qty: 3 ea

Part Name: Roller



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: RBST1000 REV.7 IPP REV:A 18.01.17 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Outsource	3 pcs		1/31/18	0.00	0.00	Outsource16		AT 18/03/21
110	Packaging	3 pcs		1/31/18	0.00	0.00	Packaging2		AT 18/03/21
120	QC	3 pcs		1/31/18	0.00	0.00	QC6		38
130	Packaging	3 pcs		1/31/18	0.00	0.00	Packaging3-2		cmf 18/03/26
140	QC21-SA	3 Ea		1/31/18	0.00	0.00	QC21		GA 137

Part Op 100 - ISSUE P/O: 039202 TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF
Descriptions: 89031009

DAS
21 MAR 7 7 2018
9-86

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
89031009	TBD	3 (1 ea)	100-Outsource	5045010

1/2 pin

Part Specifications

Specifications could not be found.

Plex 1/19/18 7:00 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation: _____

Job No: 170733
Mfg Date: 03/20/18
Packaging
Change No:
Operation:
Revision:
Serial No/ Batch: S053095
PART NO: RBST1016-5

Completed By: _____

Lead hand / Supervisor Approval Verification: _____

QC / QA Coordinator Approval: _____

Root Cause			
Environment ☐	No Re-verificatic ☐		
Design ☐	Operator ☐		
Doc/Data ☐	Offset/Setup ☐		
Equip/Tooling ☐	Supplier ☐		
Handling/Pre ☐	Training ☐		
Material ☐	Use for Testing ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Contamination ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Countersink ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Cut Too Short ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Instructions Incomplete/Unclear ☐
Past Expiry Date ☐	Manufacturing Process ☐		Drill Holes ☐
Misidentified ☐	Past Due ☐	OTHER : _____	

Positioned Wrong ☐

Outside Dimensions ☐

Over/Under tolerance ☐

Part Incorrect ☐

Part Lost/Missing ☐

Part Moved ☐

Drawing ☐

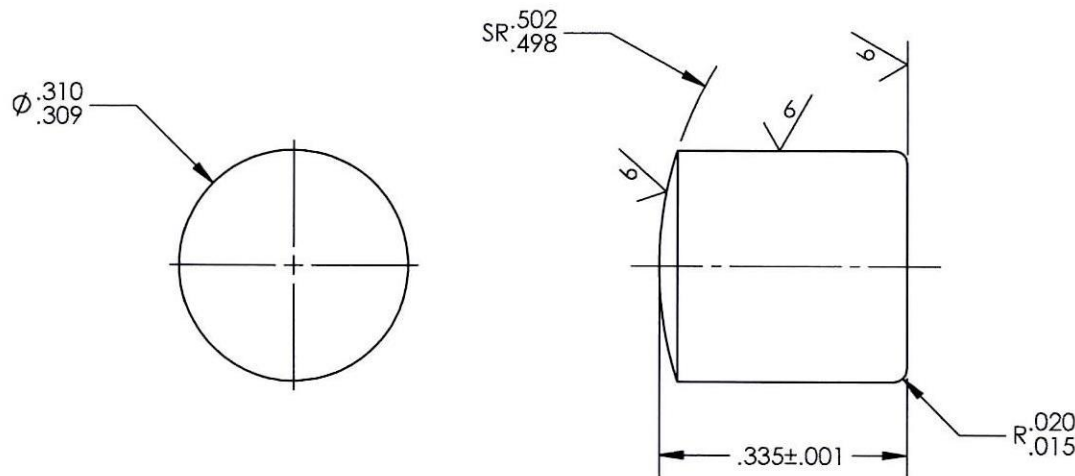
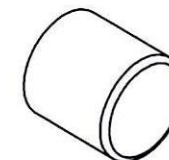
Finish ☐

Misread ☐

Turning Sequence ☐

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



TOOL NUMBER
RBST1000
RBST1001
RBST1002
RBST1003
RBST1004
RBST1005
RBST1006
RBST1007
RBST1008
RBST1009
RBST1010
RBST1011
RBST1012
RBST1013
RBST1014
RBST1015
RBST1016
RBST1017
RBST1018
RBST1019
RBST1020

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 170733 MLJ
18-01-19

(-5)
ROLLER

DART AEROSPACE	
TITLE RBST1000 THRU 1020 DRILL PRESS TRI-ROLLER SWAGING TOOL	
DWG NO. SEE TABLE-5	REV 7
MAT'L STEEL	
HEAT. RC 55-60	
FINISH	
SPEC	
DRAWN BY: PERRITT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: MACKOVJAK	USED ON MODEL
SCALE 4:1	DATE 1/4/2008
SHEET 4 OF 9	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039202**

Supplier: AFF001-VC
Affutage K.G. Inc.
11455 Philippe Panneton Ave.
Montreal
QC
H1E 4M1 Canada
Phone: 514 323 0192 514 323 6631
Fax: 514 323 6631

PO No: PO039202

PO Date: 3/5/18

Due Date: 3/14/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

REVISED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170734	RBST4241-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009	Firmed	3/14/18	6 pcs	0 pcs 6x	6 pcs AT	\$12.00/pcs	\$72.00
2	173095	RBST2854-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 1 pin make 4 pcs	Firmed	3/14/18	26 pcs	0 pcs 26x	26 pcs	\$12.00/pcs	\$312.00
3	170733	RBST1016-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009	Firmed	3/14/18	6 pcs	0 pcs 6x	6 pcs	\$12.00/pcs	\$72.00
4	171045	RBST1007-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 1 pin make 3 pcs	Firmed	3/14/18	6 pcs	0 pcs 6x	6 pcs	\$12.00/pcs	\$72.00
5	RB KIT 407M-09		Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs 3x	3 pcs	\$12.00/pcs	\$36.00

AFFUTAGE K.G. INC. K.G. GRINDING INC.

40 ans
Depuis 1975

11455 Ave. Philippe Panneton
Montréal, Québec
Canada, H1E 4M1
Tél. : 514-323-0192
Fax : 514-323-6631

Distributeur d'outils de coupe & Affutage sur mesure

Distributor of cutting tools & Custom tooling

BON DE LIVRAISON DELIVERY SLIP

DATE: MAR-14-2018

DART AEROSPACE

73005

P.O. # 39202

QTÉ	LIVRÉE	B/O	DESCRIPTION	PRIX UNITAIRE	TOTAL
6	(6)	-	RBST4241-5		
26	(26)	-	RBST2854-5		
6	(6)	-	RBST1016-5		
6	(6)	-	RBST1007-5		
3	(36)	-	BB KIT 407M-09		
3	(36)	-	" - 07		
3	(36)	-	" - 15		
6	(7)	-	" - 23		
4	(4)	-	" - 21		
3	(36)	-	" - 05		
3	(36)	-	" - 11		
2	(2)	-	" - 17		
				SOUS-TOTAL	
				TPS	
				TVQ	
				TOTAL:	

REÇU EN BONNE CONDITION / RECEIVED IN GOOD ORDER

www.kggrinding.com • sales@kggrinding.com